

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027505**Date Inspected:** 26-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Skyway**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skyway**Summary of Items Observed:**

Quality Assurance (QA) Inspector Danny Smith arrived at the new San Francisco Oakland Bay Bridge to observe, document and perform a general visual verification and NDT. Upon arrival as noted above the QA Inspector observed Quality Control (QC) on site performing welding inspection.

Skyway Guard Rail:

Gate #5:

The QA Inspector at random intervals, observed ABF welder Jayson Collins (ID 8128) perform the Shielded Metal Arc Welding (SMAW) process in the 3G/4G vertical/overhead position on face "A" of the guard rail brackets at the East bound lane gate #5 as per change order #179. The welder was observed utilizing 3.2mm E7018-H4R electrodes obtained from a baking oven and drawing amperage of 95. QC Inspector was on hand to monitor the welding, parameters as they apply to ABF-WPS-D1.5-F1200A. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QC Inspector relayed to the QA Inspector the 10mm welds on the eye brackets are being reduced to 7mm pending RFI so as to minimize welding distortion. The QA Inspector noted the welding work at this location to be not complete on this date.

Gate #4:

The QA Inspector at random intervals, observed ABF welder Jayson Collins (ID 8128) perform the Shielded Metal

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Arc Welding (SMAW) process in the 3G/4G vertical/overhead position on face "A" of the guard rail brackets at the East bound lane gate #4 as per change order #179. The welder was observed utilizing 3.2mm E7018-H4R electrodes obtained from a baking oven and drawing amperage of 95. QC Inspector was on hand to monitor the welding, parameters as they apply to ABF-WPS-D1.5-F1200A. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welding work at this location to be not complete on this date.

Work appears to be in general conformance with contract documents.



Summary of Conversations:

Conversations included welding work being performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
